

Date: Tuesday, 11/22/2005 4:58:32 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 24943
Estimate Number : 10453
P.O. Number : N/A
This Issue : 11/22/2005 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : 11/22/2005 **Type** : MACHINED PARTS
Previous Run : 24748
Written By : See comment below
Checked & Approved By : See comment below
Comment : Est Rev:C 00.06.22 Removed P/O for powder coat EC

Drawing Name : FWD MOUNTING LUG
Part Number : D26162
Drawing Number : D2616 REV D3
Project Number : N/A
Drawing Revision : D3
Material : N/A
Due Date : 12/2/2005 **Qty:** 30 **Um:** Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.1749 f(s)/Unit Total: 5.2479 f(s)
 Material: 6061-T6 QQ-A-200/8 2" X 1" Bar
 Batch M19059

ml 05/11/24 30

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 2.000" long +0.030" -0.000"

ml 05/11/24 30

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2616-2 & DWG D2616

2-Tumble & Deburr

MS 05/11/27 30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 05/11/27 30

5.0 QC8 SECOND CHECK



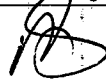
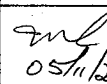
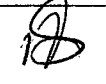
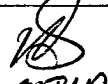

Comment: SECOND CHECK

SP 05/11/28 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 05/12/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5/11/26	3	1 piece too small the piece move in the vise <hr/> 1 piece scrap, program was wrong	 QMD	destroy and replace	 05/11/26	 05-11-28	 QMD	 05-11-28

NOTE: Date & initial all entries

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6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

ml 05/11/29 30

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3
Note: Mask large hole

ml 05/11/29 30

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J 05.11.30 30

9.0 D2611 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	B24411

P70

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

SB 05/11/30

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

SB 05/11/30

11.0 QC5 INSPECT WORK TO CURRENT STEP



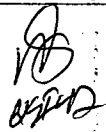
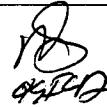
Comment: INSPECT WORK TO CURRENT STEP

J 05.11.30 30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-30	9	Parts were noticed to be 0.8150.0.003" over MAX dimension of 0.8120. bearing can be installed dry by hand, barely any press fit required.		Parts are acceptable state bearing in 8 places each side	SB 05/11/30	2 05-11-30		2 05-11-30

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 140

10 05/12/01 30

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/05 30 PP 05/12/02 30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

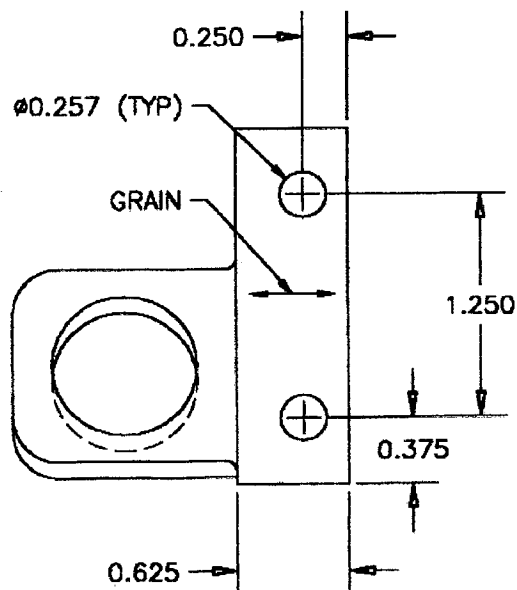
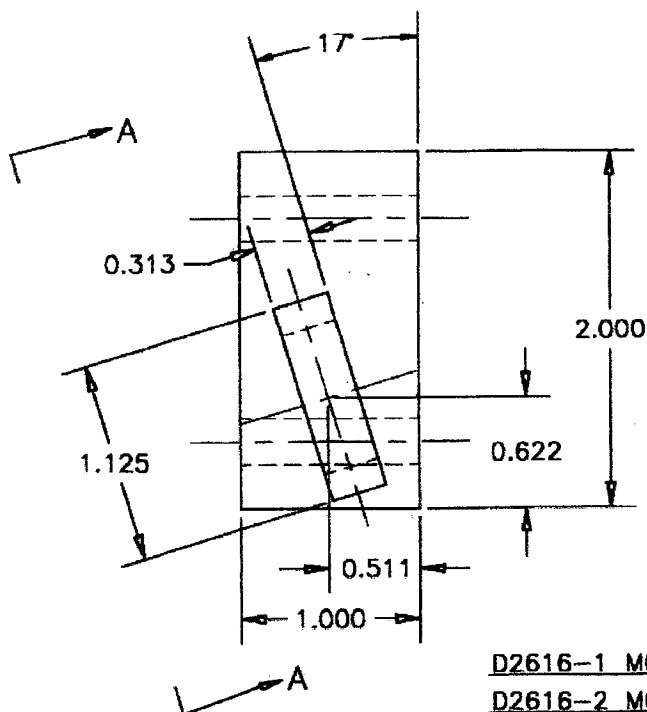
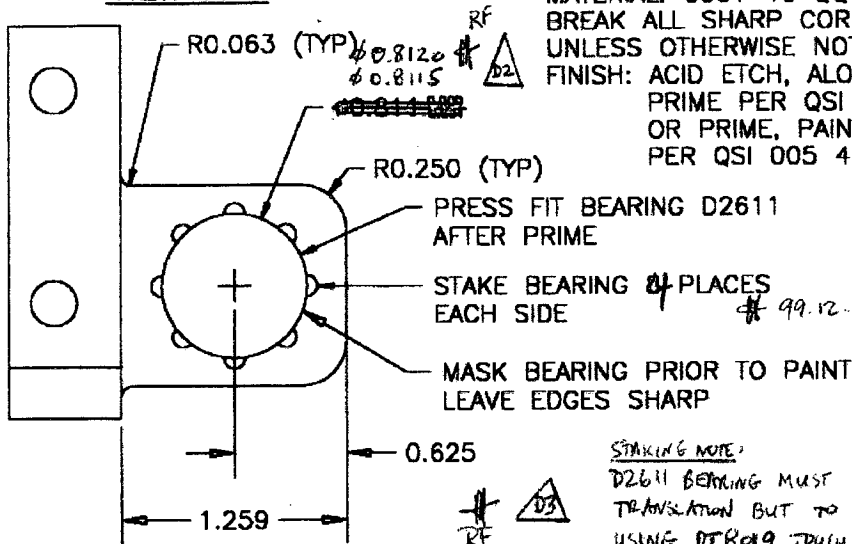
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D2616	REV. D SHEET 1 OF 1
DATE 97.07.31		TITLE FWD MOUNT LUG	SCALE 1:1
D1	99.12.16	STAKE 4 PLS INSTEAD OF 8 PLS/SIDE	A
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B
D3	02.04.30	ADD STAKING NOTE PER CAR 107	C
			D

VIEW A-A



D2616-1 MOUNTING LUG SHOWN
D2616-2 MOUNTING LUG OPPOSITE

[illegible]

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	